

Work Order ID 56559

March 1, 2010 2:32:16 PM

for sth



Page 1

Item ID: D3724-042

Revision ID:

Item Name: Step Assembly

Start Date: 3/01/10

Start Qty: 1.00

Required Date: 3/08/10

Req'd Qty: 1.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Run Start

Stop

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3724

Rev B

100



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Cut D3737-2 as per dwg D3737 2-Cut D3738-2 as per dwg D3738 3-
Debur and bevel ends for welding

10.03.02

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10.02

(+)

120



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724 2-Grind flush

10.03.03

Work Order ID 56559

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Page 2

Item ID: D3724-042

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Start Date: 3/01/10 Start Qty: 1.00

Required Date: 3/08/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

①

DD

10.03.09

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10.03.09

1

φ

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/03/09

1x

φ

Work Order ID 56559

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Item ID: D3724-042

Revision ID:

Item Name: Step Assembly

Start Date: 3/01/10 Start Qty: 1.00

Required Date: 3/08/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Apply Magnobond before installing rivets A/R Magnobond 6398
Batch: 112412 2-Rivet D3741-1 and D3730-1 to brackets before
installing on step as per dwg D3724 3-Transfer holes from D3730-1 and
D3741-1 into step as per dwg D3724 4-Debur 5-A

10-03-10

1

Ⓟ

170



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

8/10/10

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10

Ⓟ

Work Order ID 56559

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Item ID: D3724-042

Revision ID:

Item Name: Step Assembly

Start Date: 3/01/10 Start Qty: 1.00

Required Date: 3/08/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion
Touch-up Alodine

Memo

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

ML 10/03/12

(X) 0

P/P

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

ML113170

Memo

0.00

=> ML 10/03/12

(X) 0

START TIME:

3:20 PM

FINISH TIME:

OVEN TEMPERATURE:

2:00 PM

Seal all gaps with Sikaflex

QC3- Inspect Part Finish

0.00

210



QC

Quality Control

Memo



0.00

BL 10-3-18

Dart Aerospace Ltd

W/O: 56559

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.03.17	190	permanent change - ADD Chem. Conversion 5 TON# 1P ALDINE TO STEP 190		10.03.21		 10.03.21	

Part No: D3724-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56559

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Item ID: D3724-042

Revision ID:

Item Name: Step Assembly

Start Date: 3/01/10 Start Qty: 1.00

Required Date: 3/08/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Pro →

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/10/03/18

①

240



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

PPD
56558

6/24/13/18

Dart Aerospace Ltd

W/O: 56559		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/03/16	# 220	Perm. change change step to wing walk as per Q52005.	AA	10.03.24			S 10/03/16
10/03/16	# 220	wing walk as per Day and per Q52005 BUTCH. 113462	BR	10-3-18 ①			S 10/03/16

Part No: D3724-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3724-042

Revision ID:

Item Name: Step Assembly

Start Date: 3/01/10 Start Qty: 1.00

Required Date: 3/08/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop



Sequence ID/
Work Center ID

250



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

10/03/24

W 1003.18

Picklist Print

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Page 1

4

Work Order ID: 56559

Parent Item: D3724-042

Parent Item Name: Step Assembly


Comments: IPP Rev:A new issue 08-02-07 DD verified by:ec
 IPP Rev:B ecn 1154p 08-03-13 DD verified by:ec
 IPP Rev:C ecn 1158 08-03-19 DD verified by:

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
CR3213-5-4		Purchased	No			100	Each	52.0000	32.0000			
												
Cherry Rivet												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST <u>1119100</u>	52	
	110915	52	

SAD 10-03-02
PE 10-03-10

D2622-120C



Step Extrusion

Manufactured

No

120

Each

141.2400

1.0000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	141.24	
	48612	3.12	
	<u>52026</u>	15.12	
	55214	123	

32

PE 10-03-10

1

Picklist Print

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Page 2

Work Order ID: 56559

Parent Item: D3724-042

Parent Item Name: Step Assembly

Comments: IPP Rev:A new issue 08-02-07 DD verified by:ec
 IPP Rev:B ecn 1154p 08-03-13 DD verified by:ec
 IPP Rev:C ecn 1158 08-03-19 DD verified by:

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/
D2734

Replacement

Mfg/

Bin

Primary

Last

Route

Unit of

Qty on

Remaining

Qty

Date

Status



Step End Plate

Manufactured

No

160

Each

50.0000

2.0000



K 10-03-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

43535

2

48110

2

Main Warehouse

WA

46

55014

46

Manufactured

No

160

Each

3.0000

3.0000



2
K 10-03-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

38223

3

356589

3

D3728-1



Step Bracket

Manufactured

No

160

Each

3.0000

3.0000



2
K 10-03-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

38223

3

356589

3

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Shop Packet Print

Page 2

Picklist Print

March 1, 2010 2:32:14 PM

Page 3

Work Order ID: 56559

Parent Item: D3724-042

Parent Item Name: Step Assembly

Comments: IPP Rev:A new issue 08-02-07 DD verified by:ec
 IPP Rev:B ecn 1154p 08-03-13 DD verified by:ec
 IPP Rev:C ecn 1158 08-03-19 DD verified by:

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3729-1		Manufactured	No			160	Each	6.0000	1.0000			



Step Bracket



10.03.10

Warehouse Location Loc Qty Loc Code

Main Warehouse
ST

6

38468

6

160

Each

14.0000

8.0000



SAD 10-03-03

D3730-1



Angle

Manufactured

No

Warehouse Location Loc Qty Loc Code

Main Warehouse
ST

14

46893

14

160

Each

21.0000

1.0000



10.03.03

D3733-1



Gusset

Manufactured

No

Warehouse Location Loc Qty Loc Code

Main Warehouse
ST

21

38469

21

1

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Shop Packet Print

Page 3

Picklist Print

March 1, 2010 2:32:15 PM

Page 4

Work Order ID: 56559

Parent Item: D3724-042

Parent Item Name: Step Assembly

Comments: IPP Rev:A new issue 08-02-07 DD verified by:ec
 IPP Rev:B ecn 1154p 08-03-13 DD verified by:ec
 IPP Rev:C ecn 1158 08-03-19 DD verified by:

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3741-1		Manufactured	No			160	Each	16.0000	8.0000			

Angle

Warehouse

Location

Main Warehouse

ST

46754

No

Loc Qty

16

16

160

Each

Loc Code

~~B56651~~ x

6

1,053.000 12.0000

2

SAD

10-03-09

MS20470AD5-11

Purchased

Rivet

Warehouse

Location

Main Warehouse

ST

107100

No

Loc Qty

1053

1053

160

Each

757.0000 4.0000

12

SAD

10-03-01

MS20470AD5-16

Purchased

Rivet

Warehouse

Location

Main Warehouse

ST

107100

Loc Qty

757

757

Loc Code

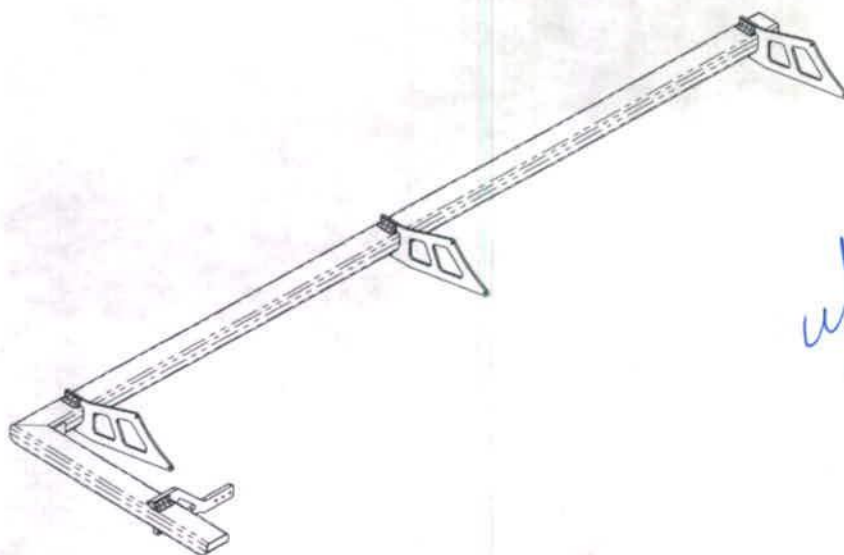
SAD

10-03-01

March 1, 2010 2:32:15 PM

Shop Packet Print

Page 4



D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE)

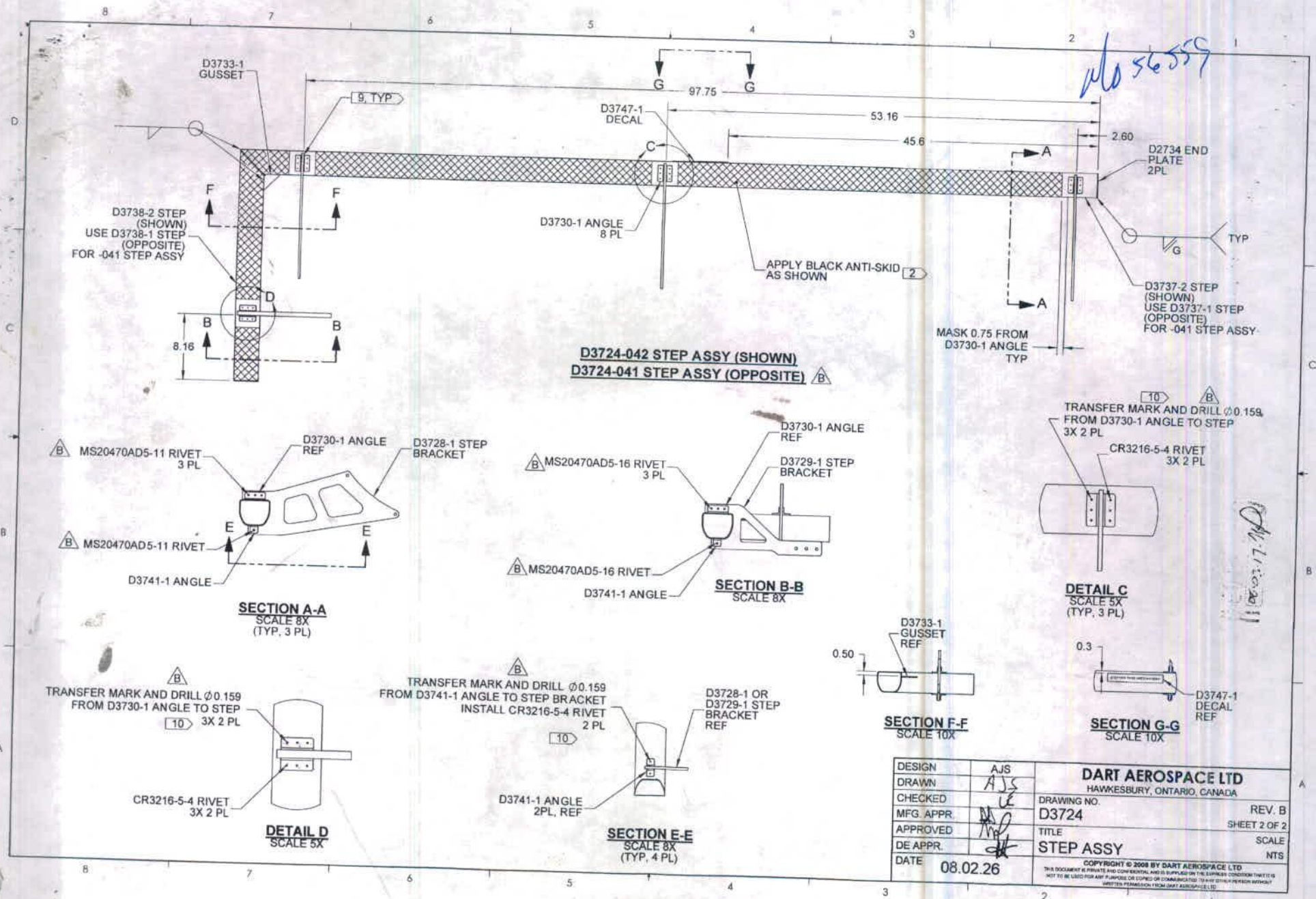
*WLO
56589*

NOTES:

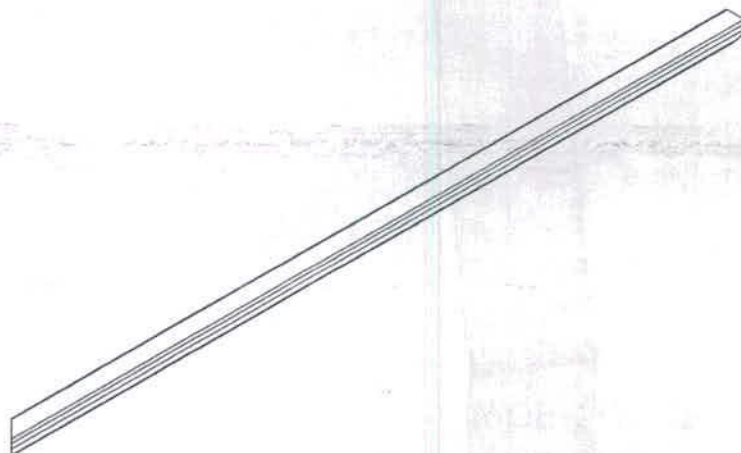
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 13.89 lbs
- 8) WELDING: PER DART QSI 004
- 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
- 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
1	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-S-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET

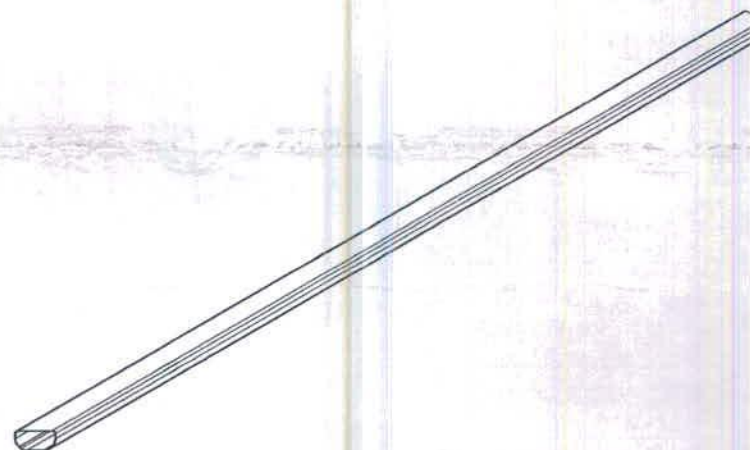
B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E Ø0.159 WAS Ø0.098. ZONE D4 53.16 DIM WAS 53.22, 2.60 DIM WAS 2.68. ADD SECTION G-G.		AJS	08.02.28
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AJS</i>		DRAWING NO.	REV. B
CHECKED	<i>LE</i>		D3724	SHEET 1 OF 2
MFG. APPR.	<i>MP</i>		TITLE	SCALE
APPROVED	<i>MP</i>		STEP ASSY	NTS
DE APPR.			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.02.26			



REFERENCE ONLY



D3737-1 STEP



D3737-2 STEP $\triangle B$

NOTES:

- 1) MATERIAL: MAKE FROM D2622-106 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.67 lbs

08.03.17.11P

B	ADDED SHEET 3 -2 WAS -1; ADDED NEW -1	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ALS		
CHECKED	HE	DRAWING NO.	REV. B
MFG. APPR.	HE	D3737	SHEET 1 OF 3
APPROVED	HE	TITLE	SCALE
DE APPR.	HE	STEP	NTS
DATE	08.03.06	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>	

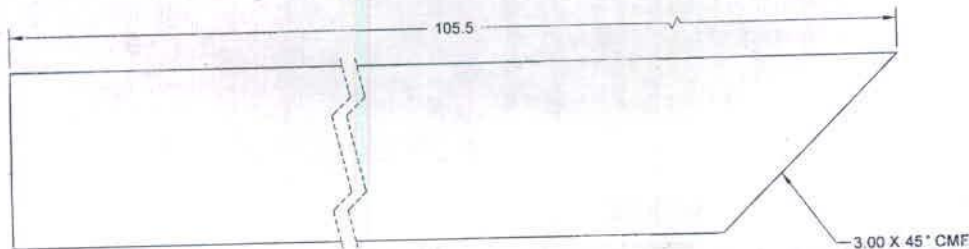
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

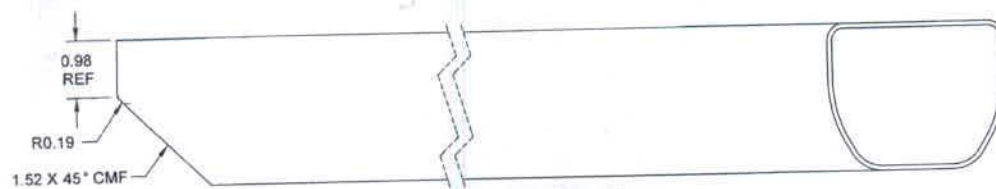
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

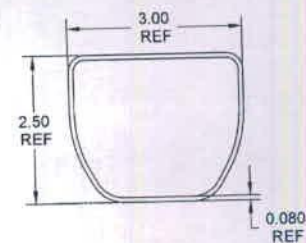
NOTE: Date & initial all entries



REFERENCE



D3737-1 STEP \triangle



08.03.17.14P

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3737	SHEET 2 OF 3
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	STEP	NTS
DATE	08.03.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

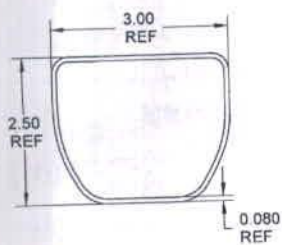
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

3.00 X 45° CMF

105.5



0.98
REF

R0.19

1.52 X 45° CMF

D3737-2 STEP

11/05/07 MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>ASS</i>		
CHECKED	<i>AVE</i>	DRAWING NO.	REV B
MFG. APPR.	<i>MP</i>	D3737	SHEET 3 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	STEP	NTS
DATE	08.03.06	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

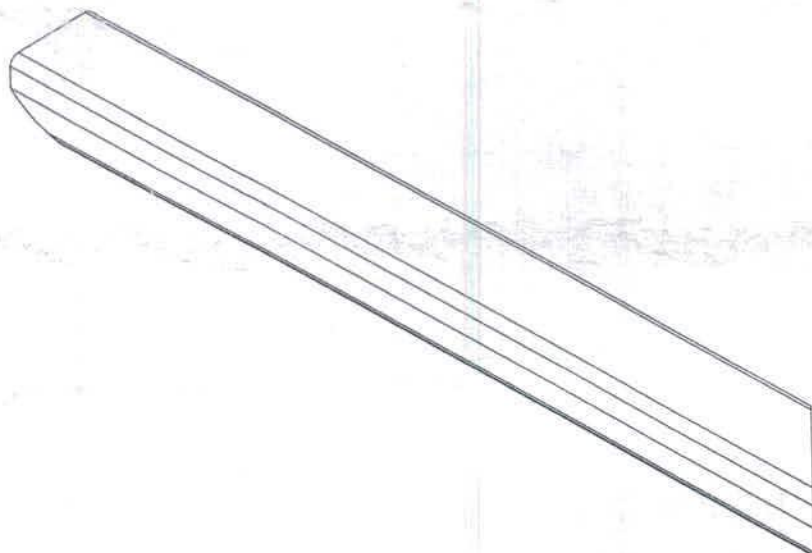
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

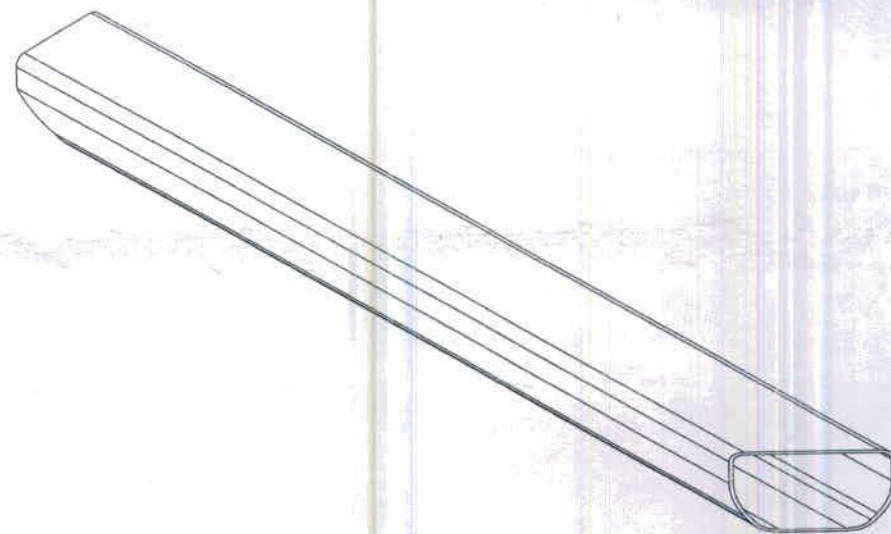
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

REFERENCE ONLY



D3738-1 STEP



D3738-2 STEP 

08.03.06

- NOTES:
- 1) MATERIAL: MAKE FROM D2622-29 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.96 lbs

B	ADDED SHEET 3, -2 WAS -1; ADDED NEW -1.	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3738	SHEET 1 OF 3
MFG APPR.		TITLE	SCALE
APPROVED		STEP	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

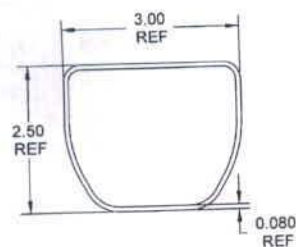
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

3.00 X 45° CMF

28.50



0.98
REF

R0.19

1.52 X 45° CMF

D3738-1 STEP $\triangle B$

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN	ASS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NE	DRAWING NO.	REV. B
MFG. APPR.	NE	D3738	SHEET 2 OF 3
APPROVED	CH	TITLE	SCALE
DE APPR.	CH	STEP	NTS
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08-03-17-ND

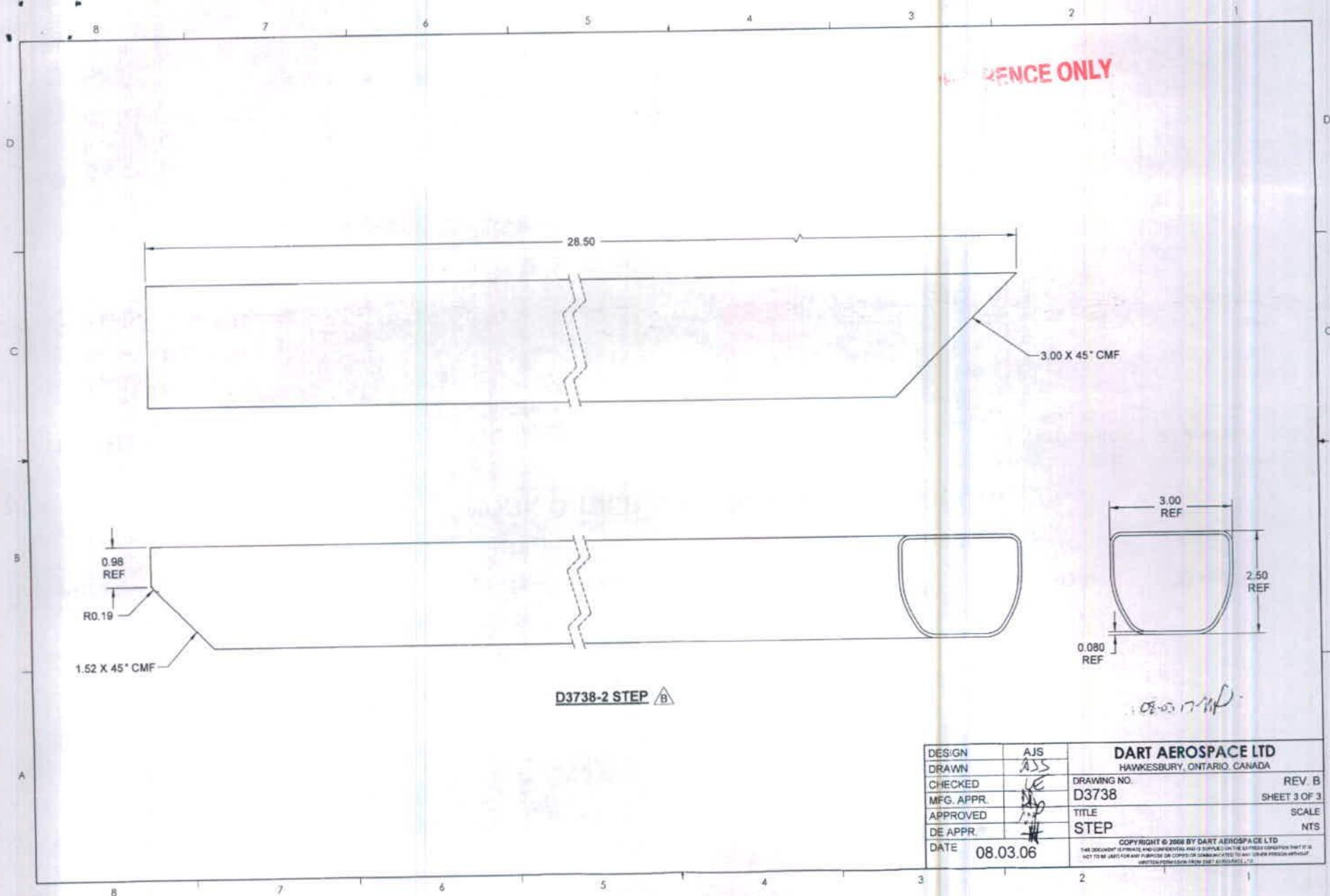
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3738	SHEET 3 OF 3
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	STEP	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE USA, INC.

REFERENCE ONLY

D206-642
Page 24 of 34

4.6 206L/L-1/L-3/L-4 HIGH GEAR SKIDTUBES

Item	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	Part Number	Description
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
			X			D206-342-441	SKIDTUBE
	1	1		X		D206-642-447	WEARSHOE KIT (REPLACES -443)
					X	D206-648-013	GROUND HANDLING KIT
	1	1				D2650-7	SKIDTUBE ASSEMBLY
1			1			D2651-1	* PLUG ⁽¹⁾
2A			22			D2651-3	* O-RING ⁽¹⁾
2B			22			D2646	* AFT CAP ⁽¹⁾
3			1			MS27039-1-08	* SCREW ⁽¹⁾
4			2			AN960JD10L	* WASHER ⁽¹⁾
5			2				
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)
22B			1	1		D3536-15	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)
24B			1	1		D3536-37	GASKET
26A			60	60		MS27039C1-08	SCREW
26B			60	60		AN960JD10L	WASHER
26C			60			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	LUG ASSEMBLY (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-7 ASSEMBLY ABOVE
⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N
Date: 09.09.09

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

[illegible]